# Nokia Customer Care
# 6015/6015i/6016i/6019i (RH-55), 6012 (RM-20) Series Transceivers

# Disassembly/Assembly

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# Safety Information

Adhere to the following guidelines when assembling and disassembling the phone.

- QUALIFIED SERVICE
  Only qualified personnel may install or repair phone equipment.
- ACCESSORIES AND BATTERIES
  Use only approved accessories and batteries. Do not connect incompatible products.
- CONNECTING TO OTHER DEVICES
  When connecting to any other device, read its user's guide for detailed safety instructions. Do not connect incompatible products.

## ESD Protection

Nokia requires that phone repair centers have sufficient ESD protection against static electricity when servicing cellular phones. Use the following guidelines:

- A cellular phone that is ready for use can be handled normally without ESD protection. The battery can be replaced in normal conditions of use.
- Use ESD protection when replacing a color cover, except for the phone covers which can be replaced by the customer.
- All electronic parts of the phone, including the display, are susceptible to ESD. Resistors also can be damaged by static electricity discharge.
- All ESD-sensitive parts must be packed in metallized protective bags during shipping and handling outside any ESD Protected Area (EPA).
- Every repair action involving opening the phone or handling the phone components must be done under ESD protection.
- ESD-protected spare part packages MUST NOT be opened/closed outside an EPA.

For more detailed information about ESD protection and EPAs, contact your local Nokia Customer Care representative.

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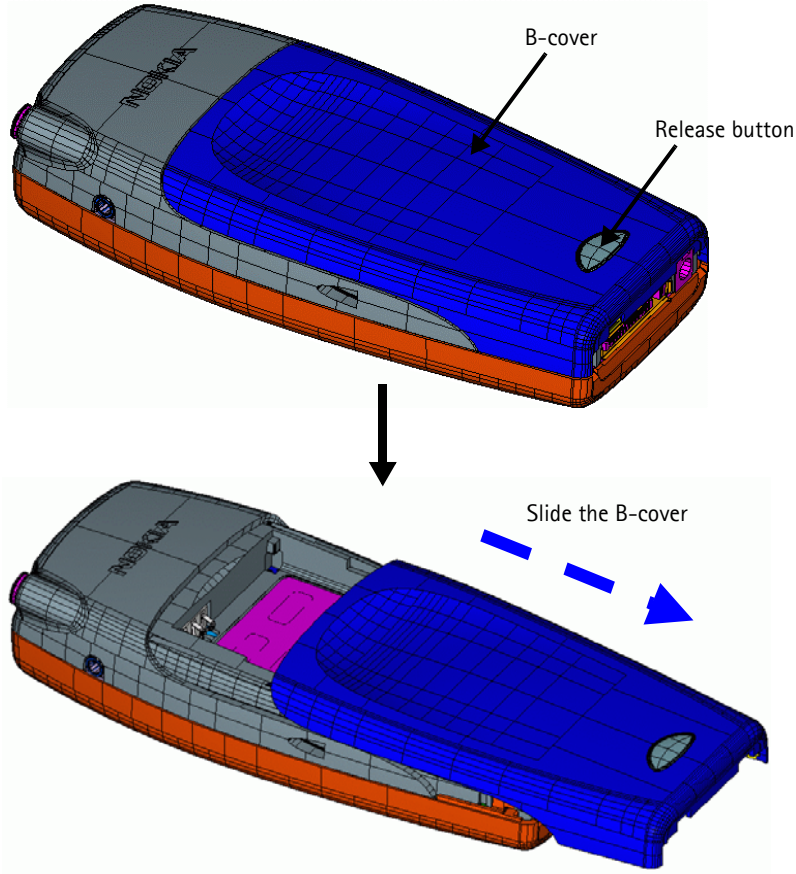
# Disassembly Instructions

Use the following steps to disassemble the phone.

## 1. Remove the Battery Cover (B-cover)

A. Turn the phone off.

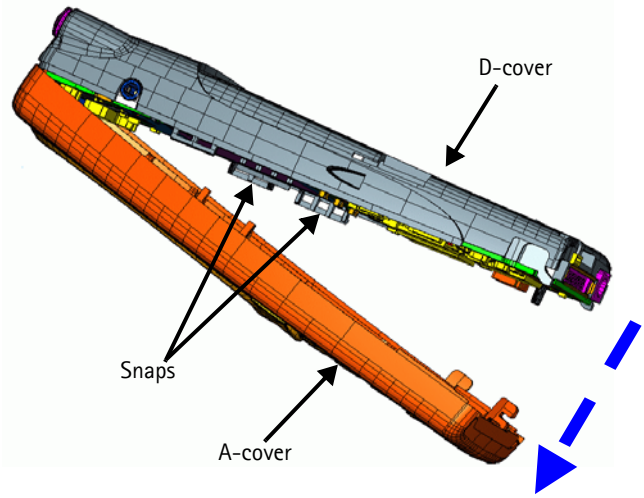
B. Push down on the release button, and slide the B-cover away from the phone.




C. Remove the battery.

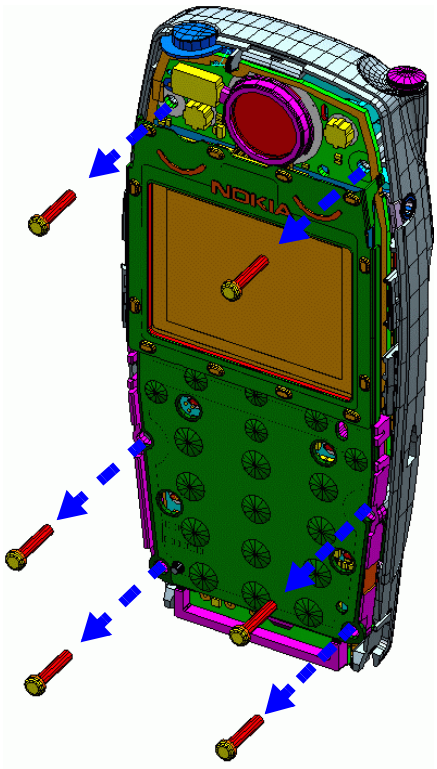
## 2. Remove the A-cover

While squeezing the sides of the D-cover at the snap locations, separate the bottom of the A-cover from the D-cover.




## 3. Remove the Screws

The D-cover screw bosses do not have threads; the threads are created using self-threading screws at the factory when the phone is assembled the first time. It is very important that when the phone is disassembled and reassembled, the original threads in the D-cover screw bosses are re-used.

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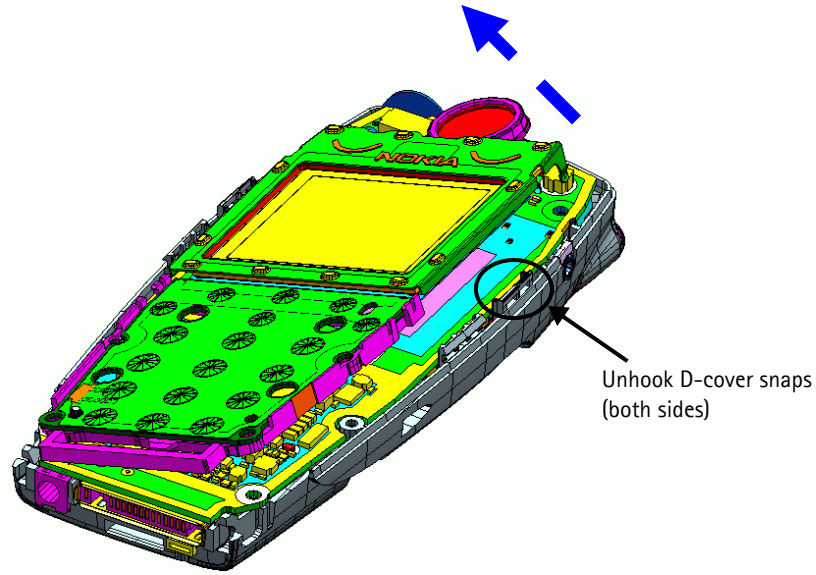
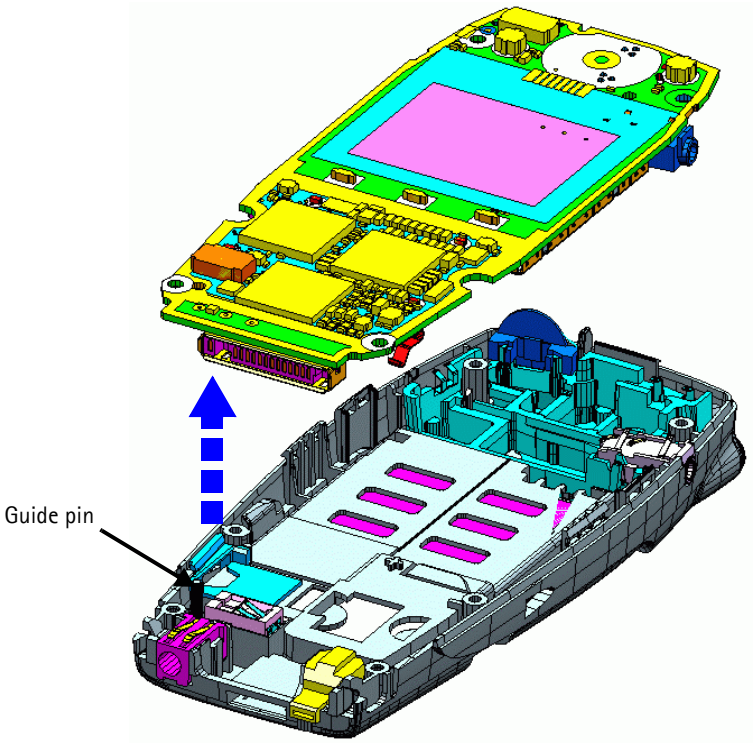
## 4. Remove the LCD Assembly

Unhook the D-cover snap on one side to free the LCD assembly from the D-cover. Repeat on the other side and remove the LCD assembly.




## 5. Separate the PWB from the D-cover Assembly

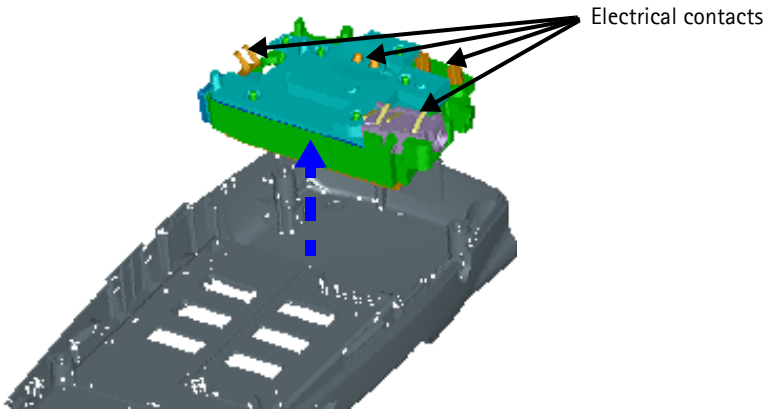
Carefully grip both sides at the bottom of the PWB and pull up to separate it from the D-cover guide pin.



## 6. Remove the Power Button

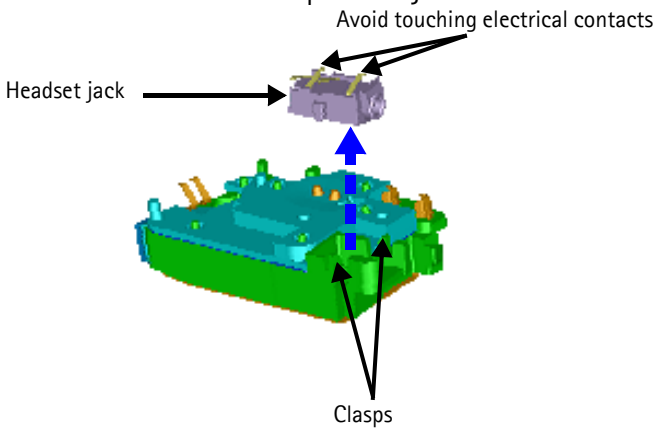
## 7. Remove the PIFA Antenna

Grasp the PIFA antenna and pull up to remove it from the D-cover. Avoid touching the electrical contacts.




## 8. Remove the Headset Jack from the PIFA Antenna

Unhook the two clasps on either side and grip the jack with tweezers to remove it. Do not touch the electrical contacts on top of the jack.

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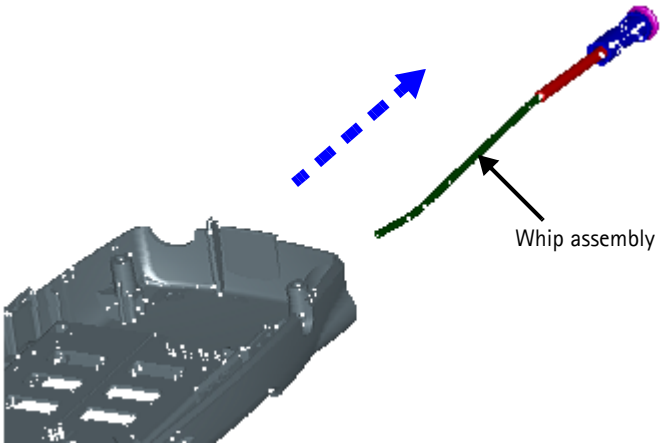
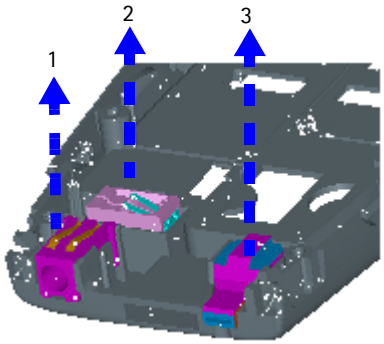
## 9. Remove the Whip Antenna

Grip the protruding end of the whip antenna and carefully pull it out of the top of the D-cover.



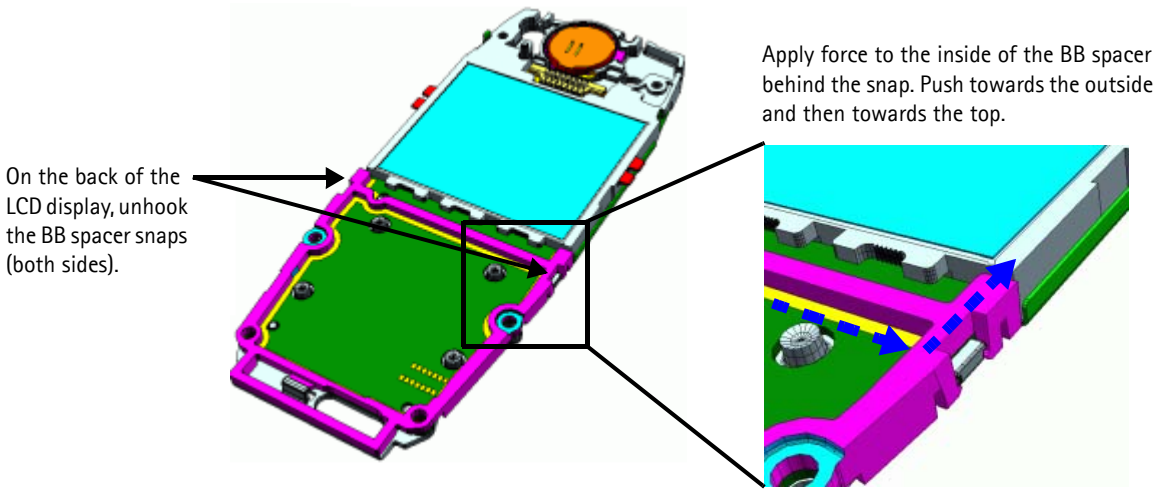

## 10. Removing the DC Jack, Vibra Motor, and Microphone

1. DC Jack - Without touching the connectors, use tweezers to squeeze the sides of the DC jack and pull up to remove it from the D-cover.
2. Vibra Motor - Use tweezers to squeeze both sides of the vibra motor and pull up to remove it from the D-cover.
3. Microphone - Without touching the connectors, use tweezers to squeeze the bottom and top side of the microphone and pull up to remove it from the D-cover.

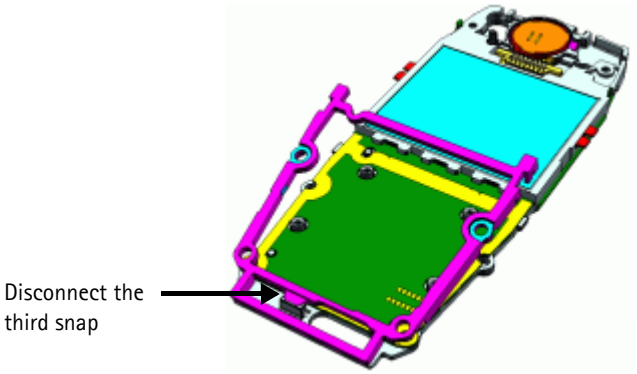


## 11. Disassembling the LCD Module

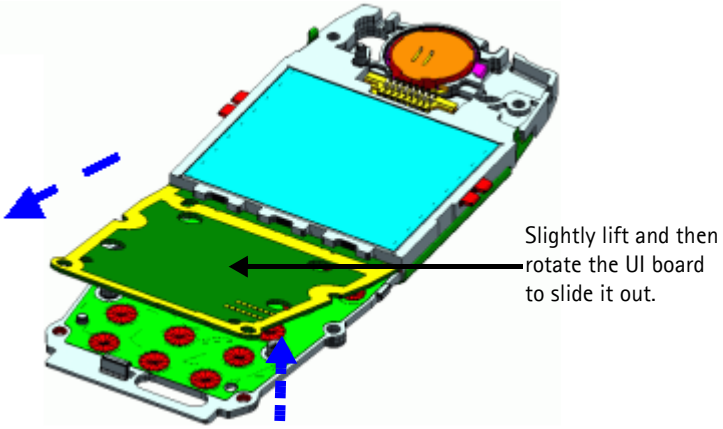
A). Disconnect the first two BB spacer snaps.


On the back of the LCD display, unhook the BB spacer snaps (both sides).
Apply force to the inside of the BB spacer behind the snap. Push towards the outside and then towards the top.

B). Remove the BB spacer by disconnecting the third snap.




C). Remove the UI board.

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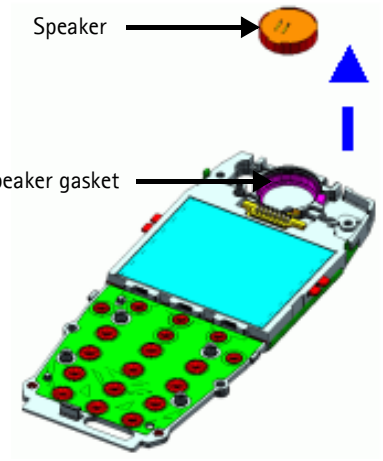
D. Remove the speaker (may require tweezers.) If necessary, you can then remove the speaker gasket.

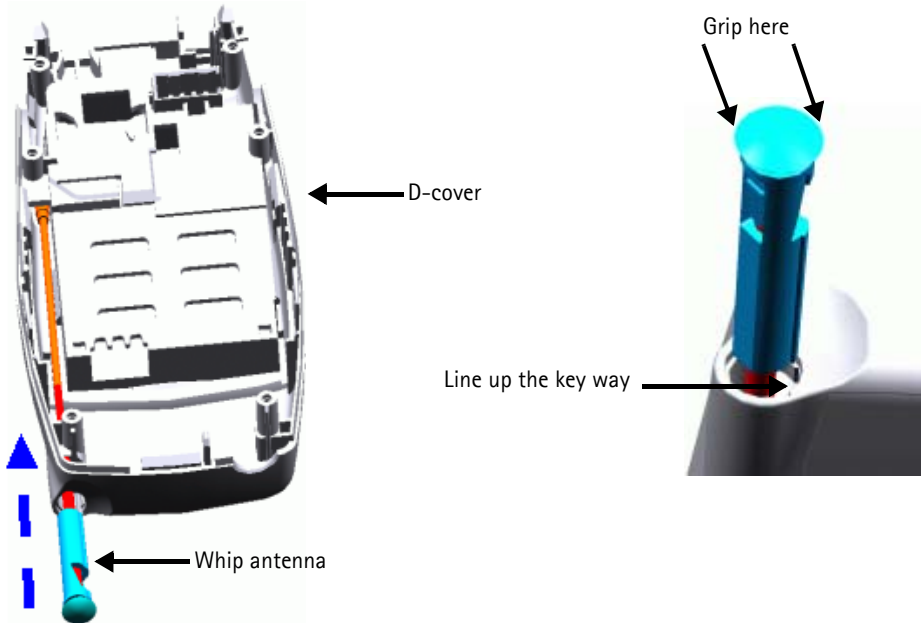


# Assembly Instructions

Use the following steps to assemble the phone.

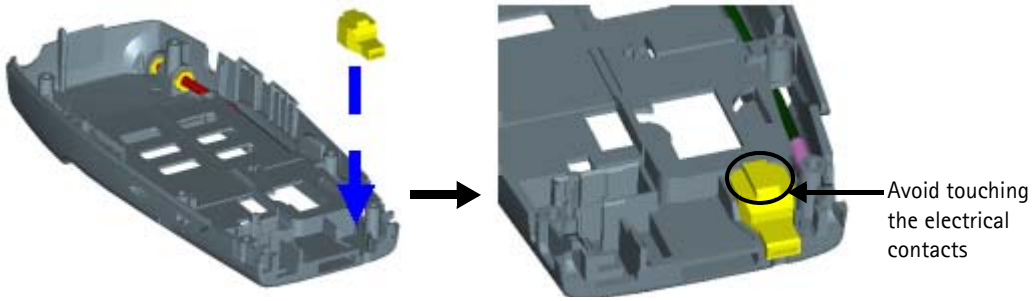
## 1. Assemble the Whip Antenna

Slide the whip antenna into the hole at the top of the D-cover. Ensure that the key is lined up and the antenna is fully inserted into the D-cover (you will feel a small click).




## 2. Assemble the Microphone

Use tweezers to insert the microphone into the D-cover without touching the connectors.

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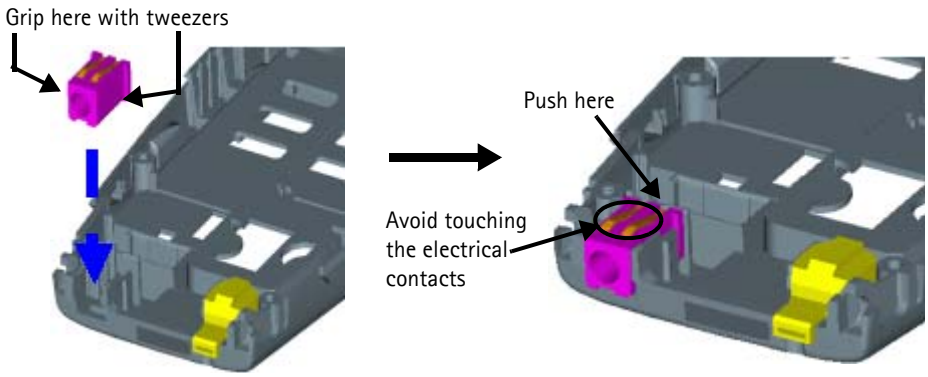
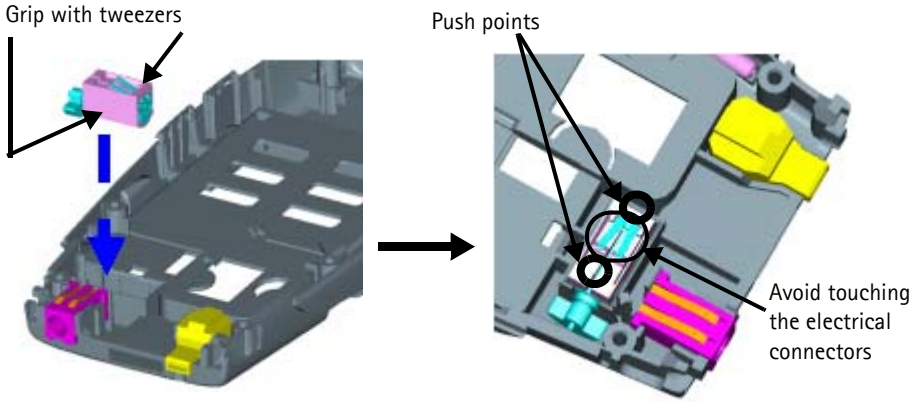
## 3. Assemble the DC Jack

Use tweezers to grip the sides of the DC jack and place it in the D-cover. Do not touch the connectors on the top of the jack. Push down on the back of the jack to ensure that it is securely in place.



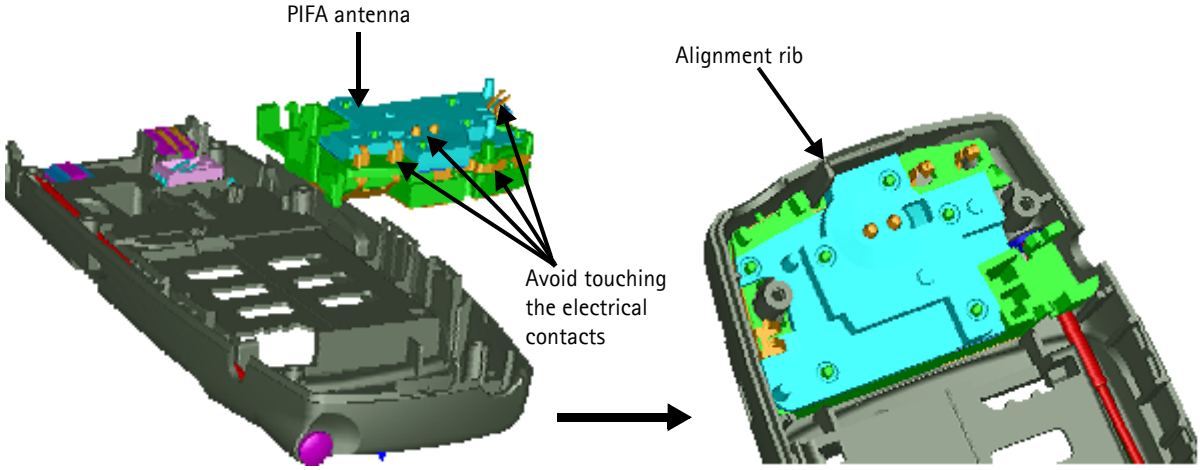

## 4. Assemble the Vibra Motor

Grip the sides of the motor with tweezers and place it in the D-cover. Do not touch the connectors on the top of the vibra motor. Push down on the top edges of the motor to ensure that it is securely in place.



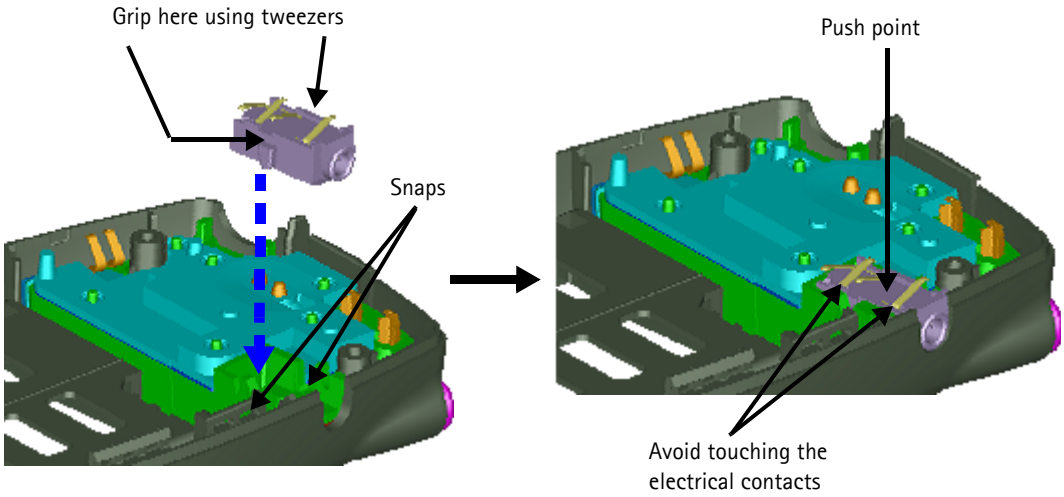

## 5. Assemble the PIFA Antenna

Grip the sides of the PIFA antenna, and place it in the D-cover using the alignment rib at the top. Do not touch the electrical contacts.



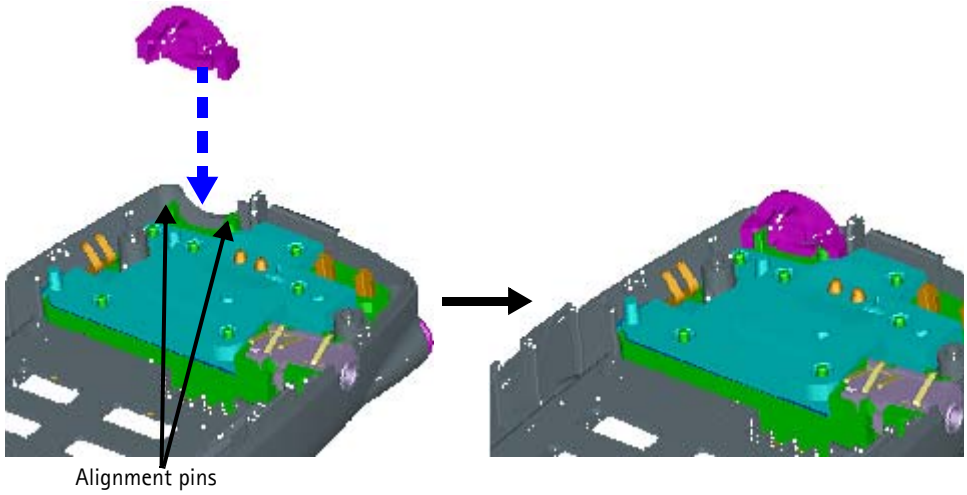
## 6. Assemble the Headset Jack

Use tweezers to grip the headset jack above the snap tabs and place the jack in the D-cover. Do not touch the connectors on the top of the jack. Carefully push down between the connectors and ensure that the tabs lock into the PIFA antenna snaps.




## 7. Assemble the Power Button

Use the alignment pins to place the power button in the slot at the top of the D-cover.

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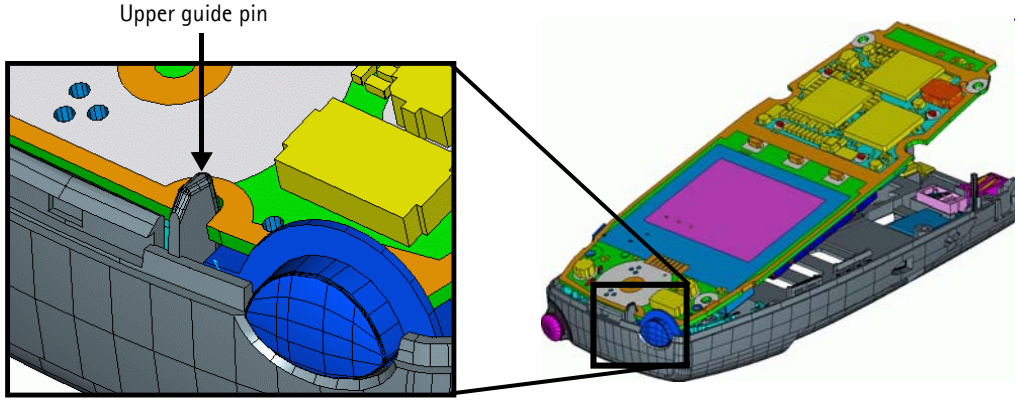
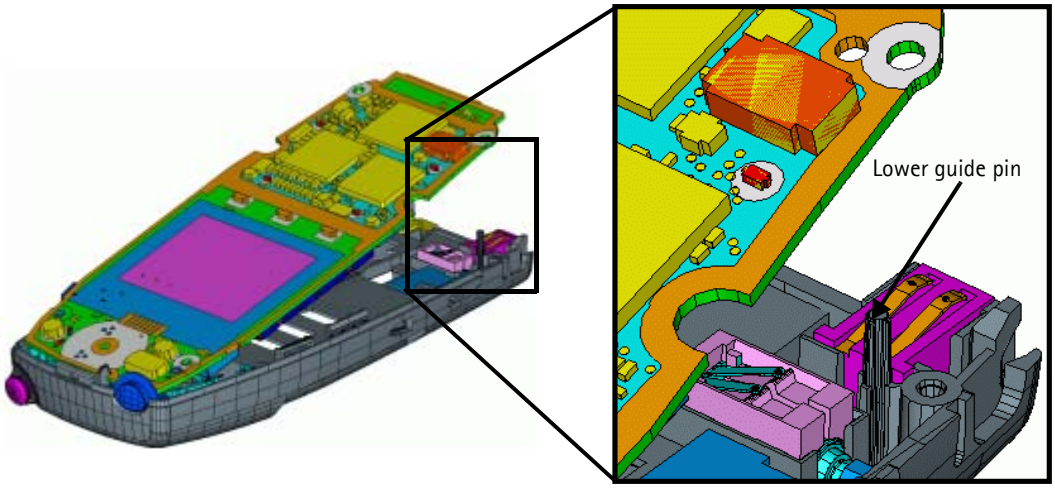
## 8. Assemble the PWB

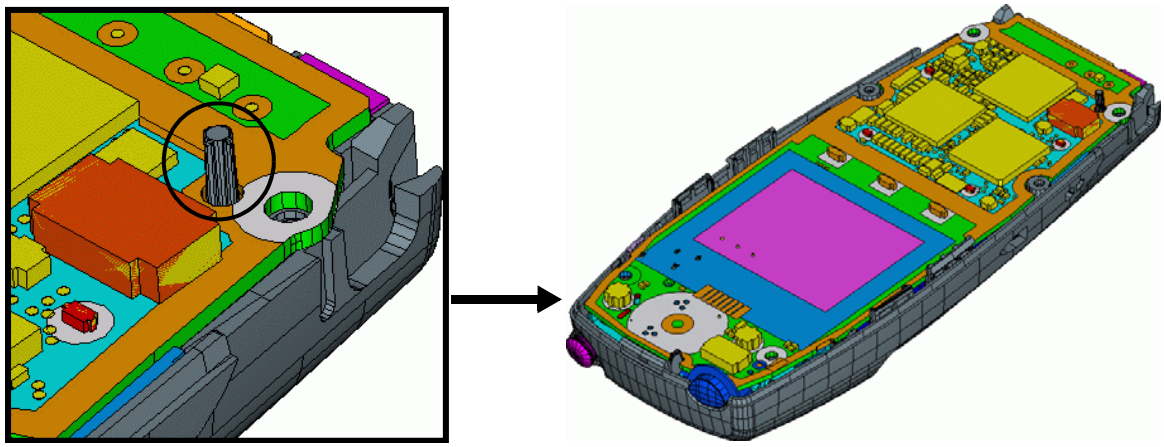
A). Use the upper guide pin to align the top of the PWB with the D-cover.




B). Use the lower guide pin to attach the PWB to the D-cover assembly.

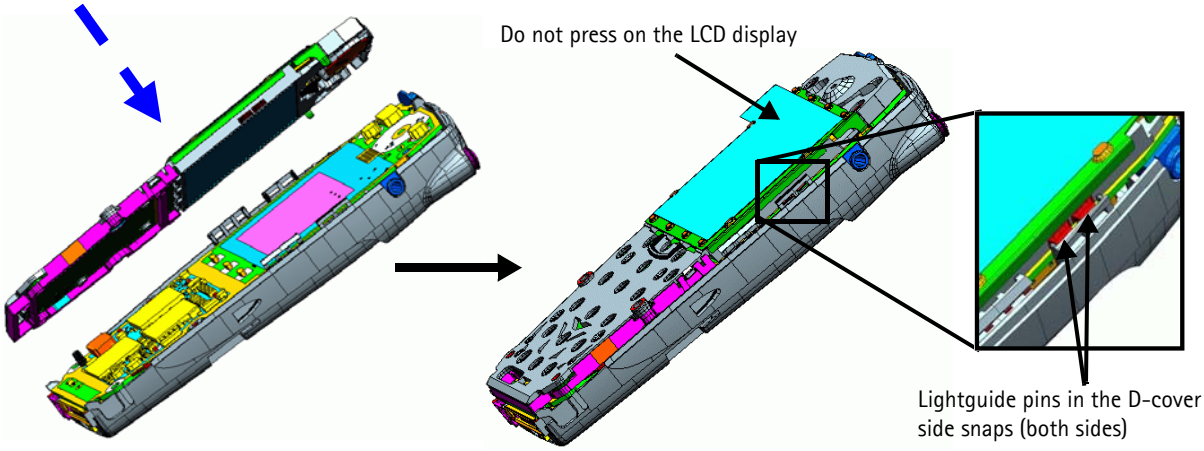



C). Ensure that the lower guide pin protrudes through the correct hole in the PWB



## 9. Assemble the LCD Display

Without touching the display, attach the LCD display assembly by aligning the lightguide pins with the D-cover snaps on both sides.




## 10. Secure the Screws

Ensure that the LCD Display Assembly (Step 9) has been properly mounted prior to securing the screws. Also, the D-cover screw bosses do not have threads; the threads are created using self-threading screws at the factory when the phone is assembled the first time. It is very important that when the phone is disassembled and reassembled, the original threads in the D-cover screw bosses are re-used.

The screw sequence should start with the two center screws, then follow with two screws at one end (either top or bottom), then finish by tightening the two screws at the other end:

a. Insert each screw by hand in the screw boss.

b. Use a manual screwdriver to turn the screw counter clockwise one turn until it feels like it is engaging in the original thread.

c. Turn the screw one turn clockwise to ensure that the screw is on original thread.

d. After you are certain the screw is in the original thread, you can use an electric screw driver. Use **21 +/- N*cm (350 RPM max)** when securing the screws.

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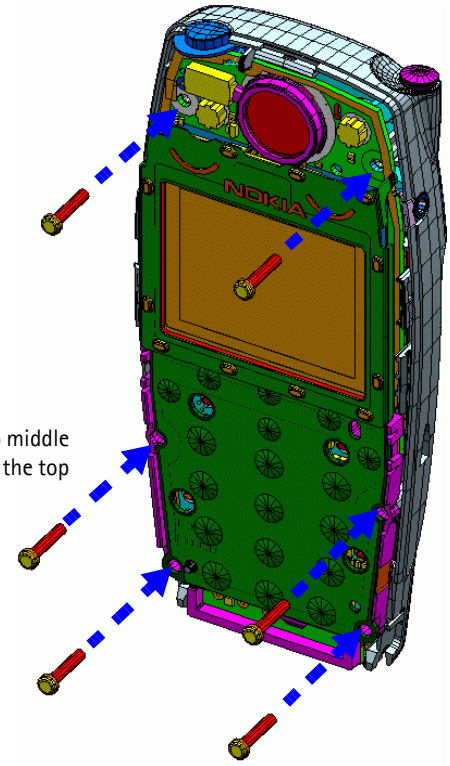
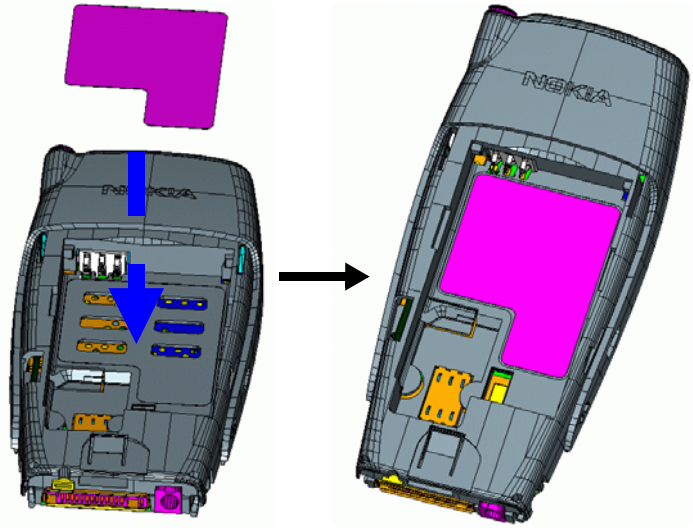


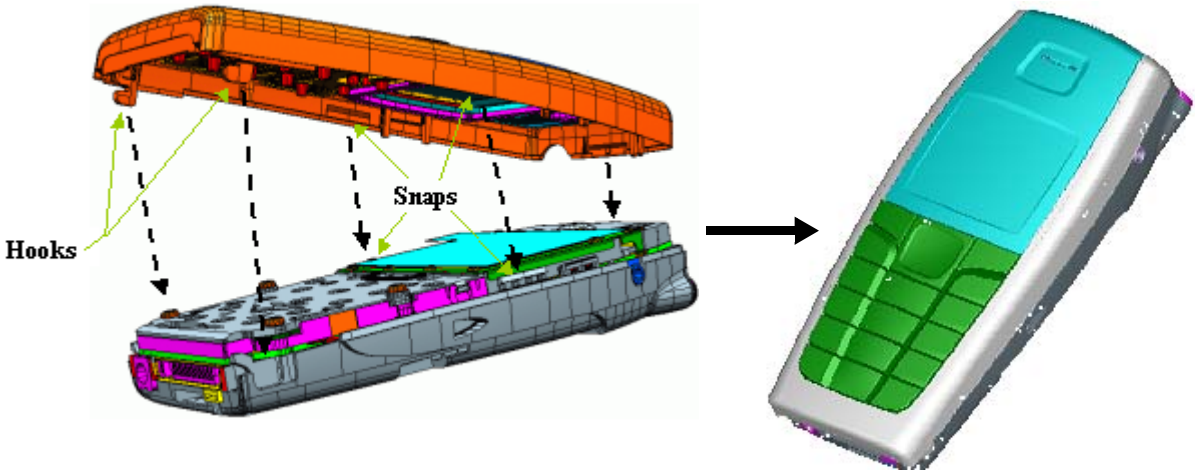

## 11. Assemble the Type Label

Insert the type label in the battery compartment of the D-cover as shown below.



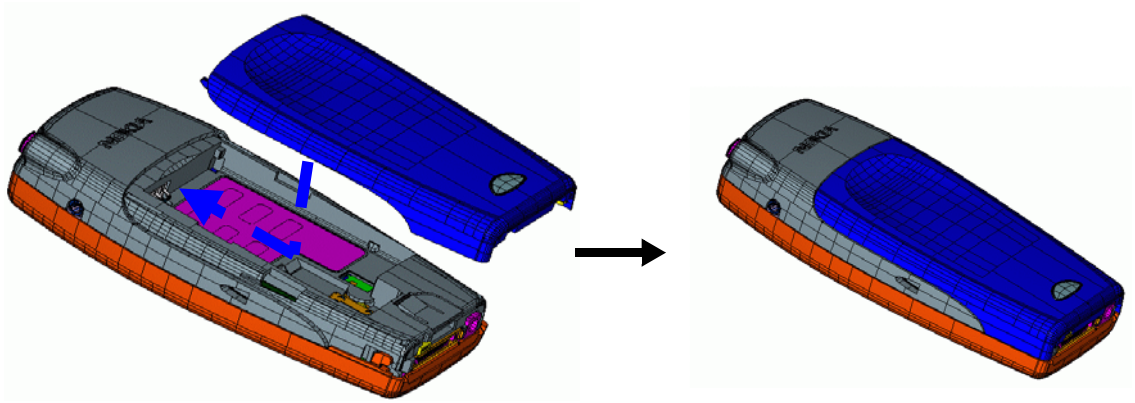
## 12. Assemble the A-Cover

Snap the A-cover to the phone assembly by aligning the snaps and hooks on both sides and the top of the assembly.




## 13. Assemble the B-Cover

Align the B-cover with the slots on the back of the phone assembly, push down, and slide the B-cover into place.



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